



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12546

Purchase Order Date 9/10/10

PO Print Date 9/10/10

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	800 363 6646	Requisition Nbr	
Vendor Fax	514 339 1105	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
C620900

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M303R1.000	303 Round Bar 1.00	9/15/10 Yes	24.00 f	Yours ppd	\$6.6667	\$160.00
Special Inst:			MATERIAL: 303 SS ROUND BAR NOTE: AISI 304/316 NOT ACCEPTABLE				
2	M304S16GA C620900	304/316 Sheet .063	9/15/10 Yes	160.00 sf	Yours ppd	\$5.2500	\$840.00
Special Inst:			MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240				
3	M6061T6A1.000W.125 C620900	6061T6 ANGLE 1.00 x 1.00 x .125W	9/15/10 Yes	40.00 f	Yours ppd	\$0.6000	\$24.00
Special Inst:			MATERIAL: 6061-T6 OR T6510/T6511 ALUMINUM ANGLE AS PER AMS-QQ-A-200/8				
MATERIAL CERTIFICATION REQ'D UPON DELIVERY			POSITIVE RECALL EFFECTIVE 10-9-07 AUTH C620900 RELEASED 10-17-07 DATE 10-17-07				
			PO Total: \$1,024.00				

Change Nbr: 1

Change Date: 9/10/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



INSPECTION CERTIFICATE

CERTIFICATE NO.: SK-99040

CUSTOMER: MAGNA STAINLESS INC(DIV OF CANADIAN SPECIALTY METALS INC.)

VOICE NO.: SSCAE40302TE9

CREDIT NUMBER: I700625

DESCRIPTION: STAINLESS STEEL SHEETS

JUN 01 2010

P/L NO.	SIZE	PCS	N.W. (KG)	SPEC	HEAT NO.	REFERENCE NO.
59	0.9mm (20ga) X 1219mm (48") X 3048mm (120")	86	2256	304 / 2B	A0639-2010	F8055
60	0.9mm (20ga) X 1219mm (48") X 3048mm (120")	86	2259	304 / 2B	A0639-2010	F8055
61	1.2mm (18ga) X 1219mm (48") X 2438mm (96")	87	2428	304 / 2B	B7113-1020	F8209
62	1.2mm (18ga) X 1219mm (48") X 3048mm (120")	64	2232	304 / 2B	B7113-1020	F8209
63	1.2mm (18ga) X 914mm (36") X 3048mm (120")	51	1342	304 / 2B	YU256274	93S51062B
64	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2433	304 / 2B	A0587-3030	F8139
65	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2434	304 / 2B	A0587-3030	F8139
66	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2435	304 / 2B	A0587-3030	F8139
67	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	58	2013	304 / 2B	A0587-3030	F8139
68	1.5mm (16ga) X 1219mm (48") X 3048mm (120")	51	2218	304 / 2B	A0587-3030	F8139

Chemical Composition

Mechanical Test

P/L NO.	C	Si	Mn	P	S	Ni	N	Cr	Mo	Y.S.(0.2%) N/mm2	T.S. N/mm2	Elongation:%	HRB
59	0.048	0.526	1.139	0.031	0.006	8.136	0.0590	18.0510	-	283	640	54.3	80.6
60	0.048	0.526	1.139	0.031	0.006	8.136	0.0590	18.0510	-	283	640	54.3	80.6
61	0.047	0.447	1.207	0.032	0.004	8.017	0.0500	18.1500	-	295	629	54.7	82.0
62	0.047	0.447	1.207	0.032	0.004	8.017	0.0500	18.1500	-	295	629	54.7	82.0
63	0.043	0.520	1.110	0.030	0.001	8.100	0.0250	18.1300	-	306	685	51.0	87
64	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
65	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
66	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
67	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
68	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7

Remark: 1. We hereby certify that the products described herein have been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

2. As per ASTM A240/480 standard.

3. The material described above has been detected with free irradiation.

Q.C. MANAGER

Jai

Chemical Composition By CastNum/Supplier



Properties

Cast Number	2BM307	Supplier	1000	Date Entered	8/18/2010
Alloy	6063	Drop Number		% Recycled	
Alloy Type	P	Date Cast		<input type="checkbox"/> Passes Specifications	
Diameter	213	Alloy Variant		<input type="checkbox"/> Inactive (not in inventory)	

Mode
☒ Inquire

☒ View

1 of 1

Show All

Done

Import from
File

Chemical Composition

Si	=	▼	0.41	Cr	<	▼	0.01	V	=	▼	0.01	Sn	=	▼	0
Fe	=	▼	0.16	Ni	=	▼	0	B	=	▼	0	Sr	=	▼	0
Cu	=	▼	0.02	Zn	=	▼	0.01	Zr	=	▼	0	Co	=	▼	0
Mn	=	▼	0.03	Ti	<	▼	0.01	Bi	=	▼	0	Al	=	▼	0
Mg	=	▼	0.48	Ga	=	▼	0.01	Pb	=	▼	0	Other	=	▼	0

Notes

Supplier's Note

Extruder's Note



CERTIFICAT DE CONFORMITÉ

Ce certificat garantit que le matériel décrit ci-dessous a été produit conformément au manuel d'assurance qualité d'EXTRUDEX ALUMINIUM (QUÉBEC) S.E.C., selon les normes
AMS-QQ-A-200/8

NOM DU CLIENT : MAGNA STAINLESS INC

VOTRE NO DE COMMANDE : 10872

NOTRE NO DE COMMANDE : 67216-01

NO DE FILIERE : SA01092-1

DESCRIPTION : ANGLE 1 x 1 x 1/8

ALLIAGE : 6061

TREMPAGE : T6

NO DE COULÉE : 2BM307

SIGNATURE :

EXTRUSIONS D'ALUMINIUM, PEINTURE ET FABRICATION

9/24/2010

770, CHEMIN OLIVIER, SAINT-NICOLAS, (QUÉBEC) G7A 2N2

TÉL.: (418) 831-4444 FAX: (418) 831-7400 INWATT: 1-800-704-4244 COURRIEL: extrudex@extrudex.ca

0002/2002

09/24/2010 VBN 8:16 FAX 418 831 7400 Extrudex Québec S.R.C.



Magna Stainless

5775 Kieran St. Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



PACKING LIST

Page 1 of 1

I032442

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7



*****STOCK***

Contact: C. LAVOIE

Ship Terms: PREPAID

MTR:Y

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		DAVE MC VETY	(613) 632-5200	(613) 632-1053	12546	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W035566	NET 30 DAYS		NIR:R-557065-1	09/16/10	09/17/10	09/17/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
2		PC	ALUMINUM ANGLES AAN 6061 T6 1" x 1" x 1/8" x R/L 20' 12 LB / 2 PC	L042208	2BM307	2
5		PC	STAINLESS SHEET SSH 304 2B 16ga x 48" x 96" 420 LB / 5 PC	L040896	A0587-3030	5
Bundles: 1			Skids: 1			Approx Weight: 432 LB

Received by: _____ Date: _____ Signature: _____

Page 1 of 1

All amounts are calculated in domestic currency.

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO12546	2		M304S16GA	Sf	9/15/2010	9/20/2010	160.0000	\$5.25	0.0000	0	\$840.00
CAD	No		304/316 Sheet .063	Sf	160.0000	DESJ02		\$840.00	0.0000	0	
			115688								
	3		M6061T6A1.000W.1 f	f	9/15/2010	9/20/2010	40.0000	\$0.60	0.0000	0	\$24.00
	No		6061T6 ANGLE 1.00 f	f	40.0000	DESJ02		\$24.00	0.0000	0	
			x 1.00 x .125W								
			115688								
									Total Received Quantity:		200.0000
									Total Qty to Inspect (PO U/M):		0.0000
									Total Reject Quantity:		0.0000
									Total Receipt Value:		\$864.00
									Total Balance Due Quantity:		0.0000

Receiving Report

Date: 10/9/17

Batch No: W115688

Supplier: Magna

Dart P/O: 12546

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order 106124 N/A ☐

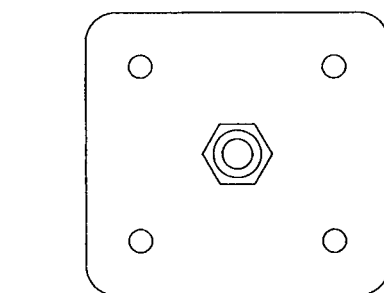
Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
303R 1"		24	0	0	24	

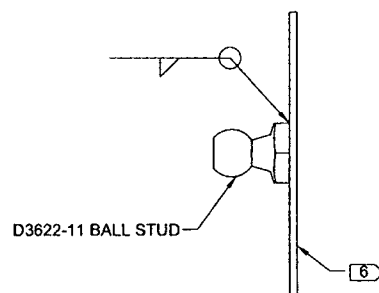
Initials of receiver (if shipment OK) Level 12 CZ

Production/Admin: 10/9/20
 Date
 Received/Costing CS
 Initial

Location _____

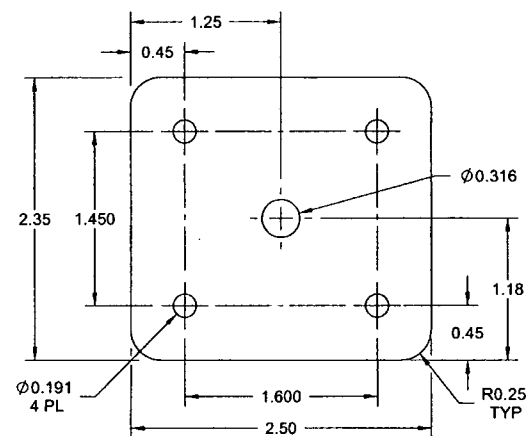


D4109-3 PLATE

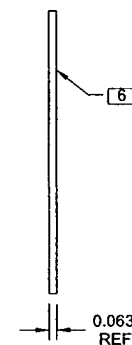


D3622-11 BALL STUD

D4109-043 DOUBLER ASSEMBLY



D4109-3 PLATE



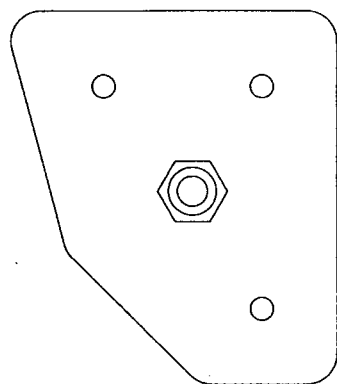
0.063 REF

NOTES:

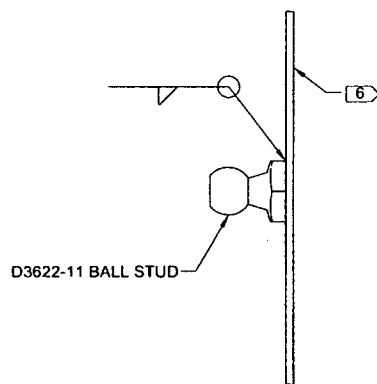
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT-043: 0.12 lbs
- 8) WELD PARTS PER QSI 004.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4109	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

62506
RELEASED
2010-09-23
MA

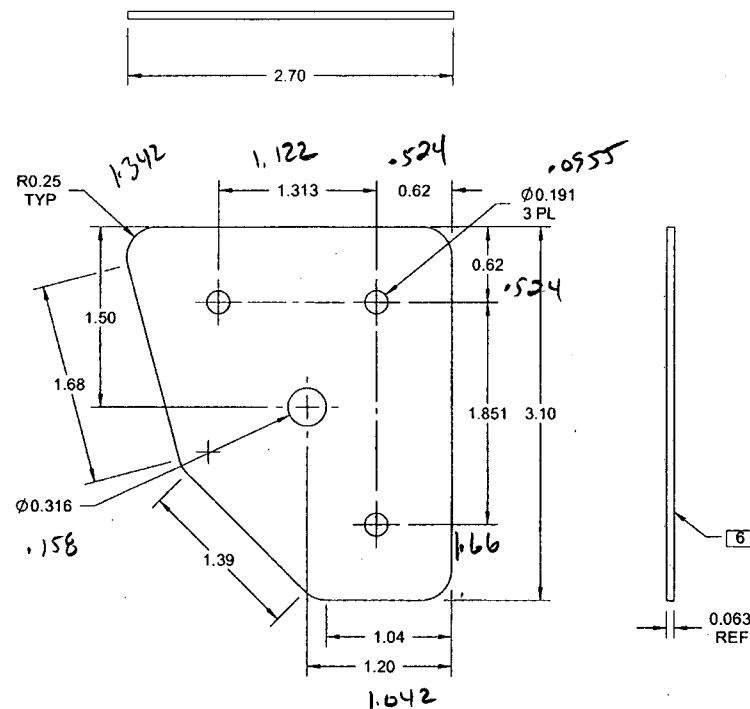


D4109-1 PLATE, BULKHEAD



D3622-11 BALL STUD





D4109-041 DOUBLER ASSEMBLY, BULKHEAD



D4109-1 PLATE, BULKHEAD

NOTES:

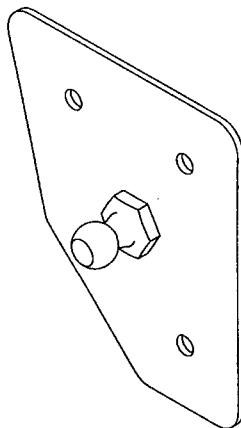
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT -041: 0.14 lbs
- 8) WELD PARTS PER QSI.004.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4109	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER ASSEMBLY	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

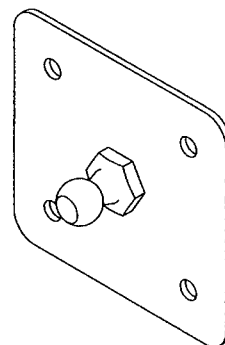
RELEASED
2010-09-23

62506

Qty -041	Qty -043	Part Number	Description
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	D4109-043	DOUBLER ASSEMBLY
1		D4109-1	PLATE, BULKHEAD
1	1	D4109-3	PLATE
1	1	D3622-11	BALL STUD



D4109-041 DOUBLER ASSEMBLY, BULKHEAD



D4109-043 DOUBLER ASSEMBLY

W/B 62506

RELEASED
2010-09-23
MP

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION		BY DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4109	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS
DATE	10.07.20		
<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

Picklist Print

October 1, 2010 10:04:20 AM

Page 1

Work Order ID: 62506



Parent Item: D4109-1

Parent Item Name: Plate, Bulkhead

Start Date: 10/01/10

Required Date: 10/05/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	76.3100	0.0581	0.244632	15		



304/316 Sheet .063



B10-10-4

Location

Loc Qty

Loc Code

MAT

70.47

111323

0

115688

70.47

MAT20

5.84

115440

5.84

115688

6

Work Order ID 62506

October 1, 2010 10:04:21 AM

Page 2

Item ID: D4109-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Plate, Bulkhead

Start Date: 10/01/10 Start Qty: 4.00

Cust Item ID:

Required Date: 10/05/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Sw 10/01/04

(x6)

QC

Memo

0.00

b Release Rev A

Quality Control

130

Identify as per dwg & Stock Location:

0.00

*welding Dave D.
SF 130*

LY 10/10/02

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

10.10.12

QC

Memo

0.00

Quality Control

*BF 10-10-15
(u)*

ASAP

Work Order ID 62506

October 1, 2010 10:04:21 AM



Page 1

Item ID: D4109-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Bulkhead

Start Date: 10/01/10 Start Qty: 4.00



Cust Item ID:

Required Date: 10/05/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

u

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4109

A

100

0.00

B10-10-4

6



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY
C210/10/04
B10-10-4